

Work Order ID 130525

Friday, March 13, 2015 12:57:49 PM

130525

Page 1

Item ID: D5062-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 3/13/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/13/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-03-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5062	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D5062-1F as per Dwg								
6061.080	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(14) _____ 02/15/03/22
 (14) _____ 02/15/03/22

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Page 2

Item ID: D5062-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket Assembly

Stop

NS2

Start Date: 3/13/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS

38

9-89

MAR 23 2015

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

Transfer drill holes as per dwg

DAS

30

9-89

APR 09 2015

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS

38

9-89

APR 13 2015

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location St 144	0.00							
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

DAS 27
APR 22 2015 **14**

MLJ 15-04-23

mk

15-4-23

Picklist Print

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Page 1

Work Order ID: 130525

130525

Parent Item: D5062-041

D5062-041

Parent Item Name: Bracket Assembly

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.02.11 NEW ISSUE DD VERF:JLM IPP
REV:B 14.05.28 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

sf

225.8168

3

M6061T6S 080

015/03/22

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT020

225.8168

m130530

45.5

m130560

180.3168

Each

2,167.000

40

MS20470AD4-5

Purchased

No

MS20470AD4-5

FF

APR 16 2015

RIVET, UNIVERSAL HEAD

Location

Loc Qty

Loc Code

GA

2095

m128401

2071

m128813

24

ST310

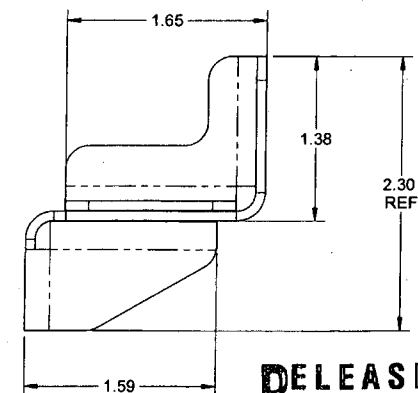
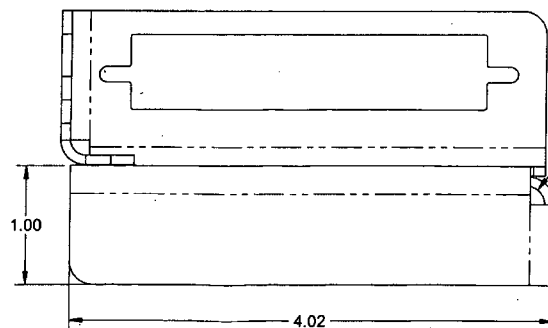
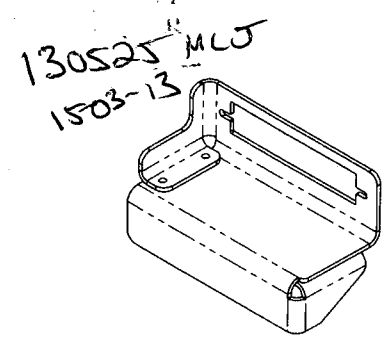
72

m128813

72

40

SECURITY
CLASSIFIED 2
COPY
PRINT
F

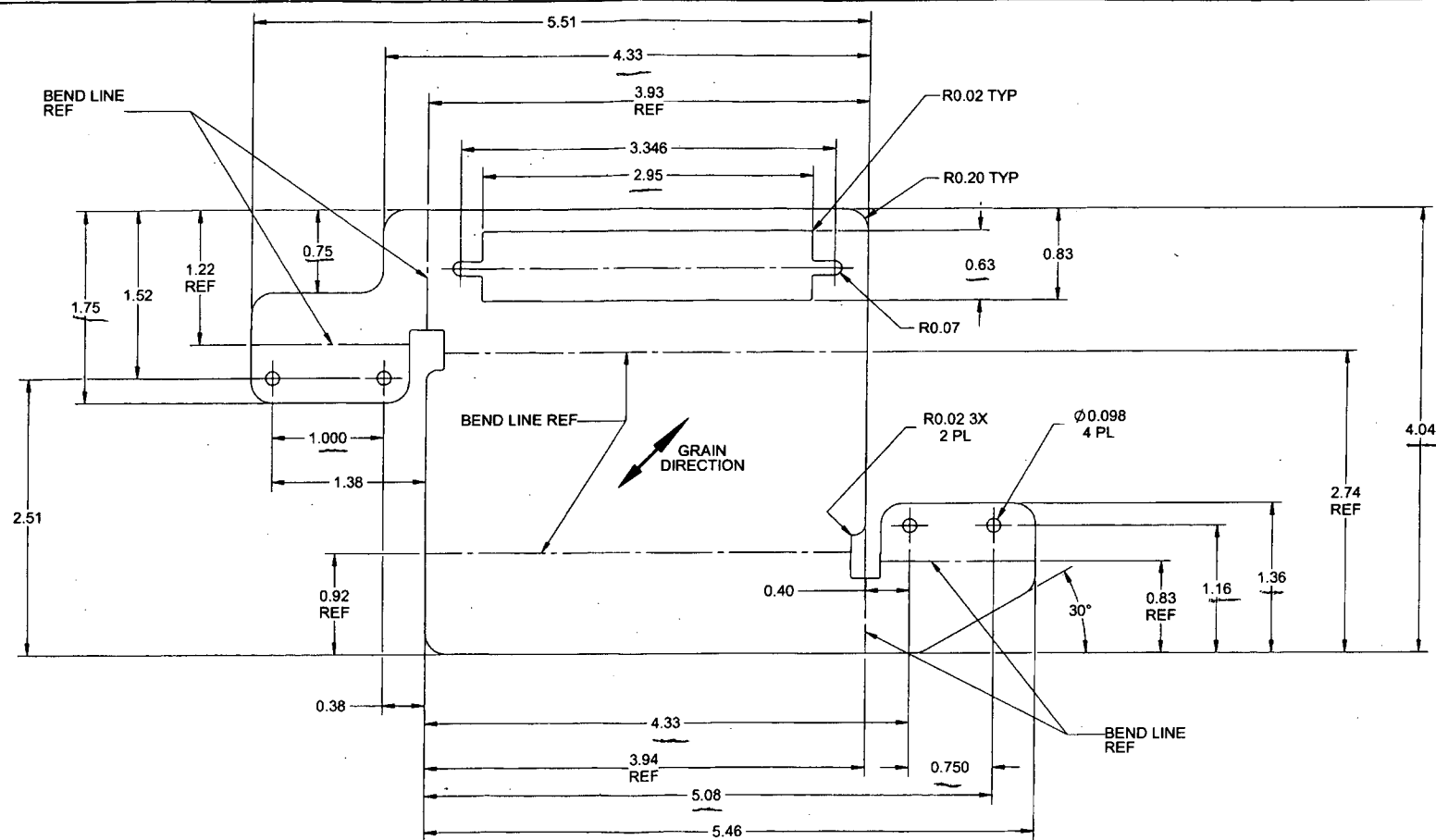


RELEASE
2014-05-28

D5062-1 BRACKET
MAKE FROM D5062-1F

- 1) MATERIAL: MAKE FROM D5062-1F
- 2) FINISH: D5062-1: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,
D5062-041: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5062-041" PER QSI 044 6.1
- 7) WEIGHT: 0.13lbs

A	NEW ISSUE		DB	14.02.10
REV.		DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5062 BRACKET		
DRAWN	DB			
CHECKED	DW			
MFG. APPR.	DD			
APPROVED	MP			
DE APPR.	DS			
DATE	14.02.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN AUTHORIZATION OF DART AEROSPACE LTD.		



D5062-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: D5062-1F: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5062-1F-A.DXF"

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5062	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
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RELEASED
2014-05-28

